

54699 Deriv

## Work Order ID 50316



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July 14, 2009 12:00:13 PM

Item ID: D3401-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Tow Cap Assembly

Start Date: 7/15/09

Start Qty: 1.00

Required Date: 7/30/09

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

09.07.16

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3401	Rev B								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks 4.20" Long

09.09.21

(10)

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA532 & Dwg D3401 □ Folio Rev: AA  
Dwg Rev: B □ Deburr

09.09.21

(10)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

09.09.21 (10)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50316



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Item ID: D3401-041 Accept  Setup Start   
 Revision ID: B Stop   
 Item Name: Tow Cap Assembly

Start Date: 7/15/09 Start Qty: 1.00  Cust Item ID:  
 Required Date: 7/30/09 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo Machine as per Folio FA532 and Dwg D3401 □ Dwg Rev: <u>B</u> Folio Rev: <u>AA</u> D3401-1 □ Deburr & Buff rad as per Dwg D3401	0.00  0.00				10	φ		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				10	φ		
150  Small Fab Small Fab	Small Fab  Memo Drill and c'sink using DT8782 as per Dwg D3401	0.00  0.00							

Identify as  
 DT 09/11/30  
 Y.A 09/12/01

cmf 09/12/02

⇒ m-h 09/12/08

10x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50316

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Item ID: D3401-041

Accept

Revision ID: B

Item Name: Tow Cap Assembly

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 1.00

Required Date: 7/30/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:35

OVEN TEMPERATURE:

325° FINISH TIME:

10:05

2) 509/12/08

2) 09/12/08

162 09-12-10

(X10)

(X10)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




# Work Order ID 50316

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Item ID:	D3401-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Tow Cap Assembly					
Start Date:	7/15/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/30/09	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	ul 09-12-16			(X10)	0		
195 11/09/12/10	Hand Finish 1- Assemble inserts as per dwg		ul 09-12-16			(X10)	0		
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	> Sorkin			(+10)			
210  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-7</u>  Memo	0.00 0.00	ul 09-12-16			(X10)	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Work Order ID 50316**

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Item ID: D3401-041

Accept

Setup Start

Revision ID: B

Stop

Item Name: Tow Cap Assembly

Start Date: 7/15/09 Start Qty: 1.00

Cust Item ID:

Required Date: 7/30/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/17 J

ME

09-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July 14, 2009 12:00:12 PM

Page 1

Work Order ID: 50316

Parent Item: D3401-041RevB

Parent Item Name: Tow Cap Assembly

Start Date: 7/15/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6R3.500

Purchased

No

200

f

15.0000

0.3684



6061 RD bar 3.50

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

15

106534

③

110993

12

NAS1330C3KB116

Purchased

No

100

Each

796.0000

4.0000



Insert

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

796

102606

200

103185

96

103337

500

1.75

1.75

07ch

1117524

X30 M 09-12-16

X10 M 09-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

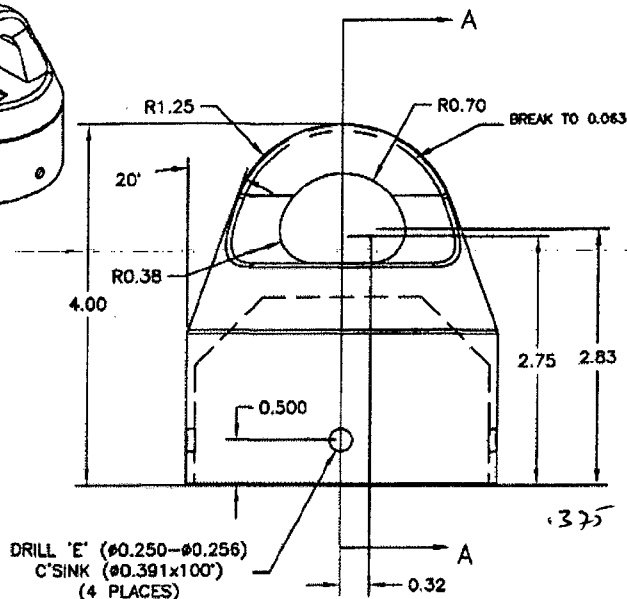
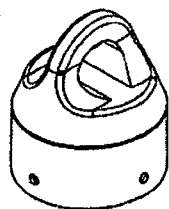
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

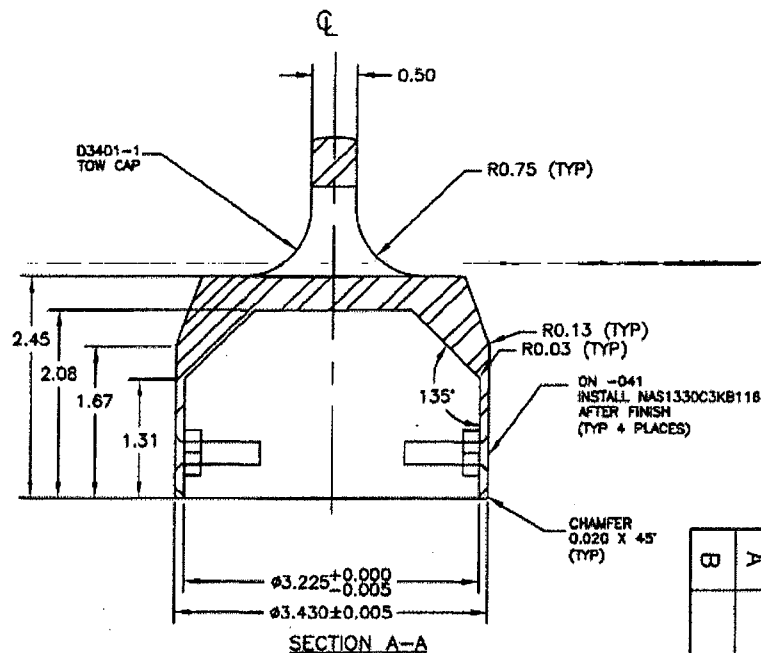
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries





**D3401-1 TOW CAP**



**D3401-1/-041 TOW CAP**

**D3401-1 TOW CAP**

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6  $\phi$ 3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3401-041 TOW CAP**

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

**D3401-041 TOW CAP PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.06.09	05.02.24	D3401
DATE	TITLE	REV. 8
05.06.09	TOW CAP	SHEET 1 OF 1
	NEW ISSUE	SCALE
	CHAMFER INSIDE, REMOVE RADIUS	1:2

RELEASED  
05-08-01

w/o 50316